Wednesday, 6/7/2006 12:02:00 PM Kim Johnston User: **Process Sheet** : SPACER : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer : 27444 Job Number : 10383 **Estimate Number** : D30661 **Part Number** : NA P.O. Number S.O. No. : NIA **Drawing Number** . D3066 REV. A : 6/7/2006 This Issue : N/A Project Number : NC Prsht Rev. : NIA : MACHINED PARTS Type **Drawing Revision** First Issue : NIA : 26258 Material **Previous Run** : 6/14/2006 Qty: 40 Um: Each **Due Date** Written By Checked & Approved By Incorporated D3066-1 IPP KJ/RF Comment **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: 5052-H32 .080 Sheet M5052H32S080 1.0 Comment: Qty.: 0.0992 sf(s)/Unit Total: 3.9590 sf(s) Material: 5052-1432 (QQ-A-250/8) 0.080" thick Batch: 1/1/00 (M5052H32S.086) Comment: SHEAR -0.000/+0.010 Cut blank: 16.490" x 0.750" HAAS1 Machine as per Follo FA280 and Dwg D3065 Stack of 10 Identify as D3066-1 QC2 4.0 PARTS AS THEY COME OFF MACHINE Comment: INSPECT SECOND CHECK 5.0 Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES									
DATE	STEP	4	PROCEDURE CHANGE		Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector		
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	A	0					-				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
D.4.77	OTER	Description of NC	Corrective Action Section B			Verification	Approval	Approval		
DATE	STEP	Section A	Section A Initial Action Description  Design Mgr Design Mgr		Sign & `Date	Section C	Design Mgr	QC Inspector		
060612	3	I parts script these I have an each part elongiples	09242	senape clastical	Dh.		B			
,		from Warre Jet			06-06-16	060612	ase-12	06-06-R		
06.06.14	3	Motil .060. Dwg vier requires .080. Parts notinspected properly didn't measure matil thickness.	De D	SUMP STACKS i replace WIH .080. GOG! TO MAT!	W	1	OFF			
-		mensure matil thickness.			808 15	660615	•	0606:14		
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Part No:	PAR #:	Fault Category: NCR:	Yes	No DQA:	Date:
NOTE: Date & initial all entries			QA:	N/C Closed:	Date:

Wednesday, 6/7/2006 12:02:00 PM Date: User: Kim Johnston Process Sheet **Drawing Name: SPACER** Customer: CU-DAR001 Dart Helicopters Services Part Number: D30661 Job Number: 27444 Job Number: **Machine Or Operation:** Description: Seq. #: SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 6.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack 7.0 QC5 WORK TO CURRENT STEP Comment: INSPECT HAND FINISHING RESOURCE #1 8.0 SAN 06: 06: 1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 9.0 Comment: INSPECT CHEMICAL CONVERSION COAT PACKAGING RESOURCE #1 10.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WA 18 DOCUMENT CONTROL DC 11.0 Comment: DOCUMENT CONTROL 06/26/21 Inspection Level 21 Job Completion

Page 2

Form: rprocess

## **Dart Aerospace Ltd**

W/O:			WOI	RK ORDER CHANGE	S				
DATE	STEP	PR	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approva QC Inspector
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NCR:		·	WORK ORDE	R NON-CONFORMAN	ICE (NCF	₹)			
DATE	STEP	Description of NC		Corrective Action Section E		Verific	ation	Approval	Approval
DAIE	SIEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign 8 Date	Section		Design Mgr	QC Inspector
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Part No	):	PAR #:	Fault Category:	NCR:	Yes No	DQA:		Date:	**
NOTE: D	ate & initial al				OA: N/C CI				

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D3065-5DART AEROSPACE LTD	Work Order:	27444
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: A		Page 1 of 1

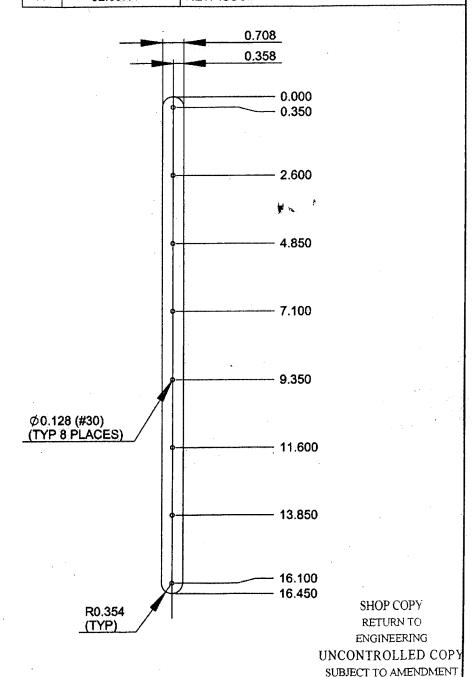
## FIRST ARTICLE INSPECTION CHECKLIST

		X First A	rticle	Prot	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
Ø0.128	+0.005 -0.000	0.198	1		vern		
0.708	+/-0.010	0.709	J		vern		
0.358	+/0.010	0.352	<b>V</b>		Vern		
0.350	+/0.010	0.348	V		vern		4
2.250 (Pitch)	+/-0:005	2.250	$\mathscr{N}$		vern		
16.450	+/0.010	16.450	<b>/</b>		MOASUring TA	Pe	
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				7	1		
Measured by:	MM	Audited by	í: /		Prototype Appr	oval:	N/A
Date:	56 06.08	Date	: 105.06	12		Date:	N/A
Rev Date	Change				Rev	ised by	Approved
A 03.09.22	New Issue	P/O D30	65-041		KJ/F	₹F .	A-



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DESIGN	P	DRAWN BY	DART AERO HAWKESBURY, O	
CHECK	#	APPROVED	DRAWING NO. D3066	REV. A SHEET 1 OF 1
DATE	02.0	09.11	SPACER	SCALE 1:3
 Α	0	2.09.11	NEW ISSUE	





## **D3066-1 SPACER**

1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H328:080) TICE
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order: 경기식4니
Description:	Part Number: D3066
Inspection Dwg: , Rev:	Page 1 of

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dimension  Dimension	+ .005 005	0.130	1	<u>,</u>	yern	
0.708	+1-0.010	0.711			vern	
0.358	+1-0.010	0.358	V		Vern	
0.350	4-0.010	0.351	$\checkmark$		vern	
2.250(ph	1+1-0.005	2.248	V		Vern	
16.450	+1-0.010	16.450-	V		Monsuring +	ree
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Measured by:	M.M	Audited by:	6/	Prototype Approval:	
Date:	BO6 14	Date:	nL 106:15	Date:	

	Rev	Date	Change	Revised by	Approved
ſ	Α		New Issue	KJ/JLM	